

**Abstract**

The invention relates to a method for producing an effectively invisible gemstone setting by casting a wax model of the setting and inserting a flange or post between the stones and into the floor of the setting, or into a depression or aperture on the floor of the setting, in order to secure the stones placed in the wax model of the setting. The flange is shaped so that the majority of its body is hidden beneath the gemstones and so that a narrowed portion of the flange engages the sides or girdles of the gemstones. The upper portion of the flange has sloped sides and may reflect light to and from the crown of the gemstones mounted in the setting.